



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

608726

D135-1027-201
Job Sheet 190483



Part No: D135-1027-201

Job Qty: 1 pcs

Part Name: Standard Height AFT Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/8/19

Job Tracking No:

Due Date: 3/28/19

Created By: Jesse White

Type: SOLD

Description:

Note: IIN-D135-1027 REV:C IPP REV:A 17.10.24 NEW ISSUE DD VERF:JFS IPP REV:B 18.11.08 AS PER IIN
REV:C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs		3/28/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

MAR 22 2019 APR 23 2019



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S174310



Part: D135-1027-201

Job No: 190483

Serial No/Batch: S174310

Revision: C

Inspector:

Exp Date:

Instructions: TC STC SH18-49 Issue 1, FAA-STD SR042761

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
110 QC 4	1 pcs	3/28/19	0.00 0.00		QC 4 - 26	
					QC 4 - 28	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	F.D. DAS 69 9-89
					QC 4 - 9	
					QC 4 - 46	DAS 69 9-89
130 Packaging 3-1 - Stock - B4B	1 pcs	3/28/19	0.00 0.00		Packaging 3 - 1 - B4B	F.D. DAS 69 9-89
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
135 DC - 1 - B4B	1 pcs	3/28/19	0.00 0.00		DC - 1 - B4B	DAS 21 9-89
					DC - 2 - B4B	
140 QC 21 - FG	1 pcs	3/28/19	0.00 0.00		QC 21 - FG - 21	DAS 21 9-89
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op 100 - (Pick Kit)

Descriptions: 110 - (QC4- 100% Inspect kits for completeness)

130 - Package as per PPP D135-1027-201 Identify and Stock Location :

135 - (Document Control) Photocopy blue file & type labels as per PPP D135-1027-201 CHG 001

140 - (QC21- Final Inspection - Work Order Release)

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310C8	Nut	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5156898
AN4-44A	Bolt	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	EM137480
D135-1027-241 <i>Qc.4</i>	STD HEIGHT AFT Crosstube Assembly	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5171986
D5415-3 <i>ENG</i>	STD Height Saddle	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5172526
D5416-1	Bushing	4 pcs (4 ea)	100-Packaging 1 - Pick Kit	5032829
D5417-1	Support Plate	4 pcs (4 ea)	100-Packaging 1 - Pick Kit	F515568x2 5036072x2
D5464-1	Washer	4 pcs (4 ea)	100-Packaging 1 - Pick Kit	5033379
D5541-041	Ground Handling Pin Assembly	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5037615
D5541-3	Ground Handling Nut	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5035389
MS21042-5	Nut	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5149145
MS21043-3	Nut	12 Ea (12 ea)	100-Packaging 1 - Pick Kit	5149144
MS21920-32	Clamp	13 Ea (13 ea)	100-Packaging 1 - Pick Kit	5075171
MS24665-306	Cotter Pin	8 Ea (8 ea)	100-Packaging 1 - Pick Kit	EM137878.70
NAS1149C0363R	Washer	12 Ea (12 ea)	100-Packaging 1 - Pick Kit	5132415
NAS1149D0563J	Washer	8 Ea (8 ea)	100-Packaging 1 - Pick Kit	5156686

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	AN310C8	4	21	0
	AN4-44A	2	27	0
	D135-1027-241	1	1	0
	D5415-3	2	3	0
	D5416-1	4	40	0
	D5417-1	4	41	0
	D5464-1	4	32	0
	D5541-041	2	6	0
	D5541-3	2	6	0
	MS21042-5	2	0	0
	MS21043-3	12	1,382	0
	MS21920-32	13	200	0
	MS24665-306	8	78	0
	NAS1149C0363R	12	645	0
	NAS1149D0563J	8	973	0

Remove

Add

4x D5720-041 5176788

Part Specifications

8/19 2:41 PM dart.white.jesse

190480 - correct
- D5415-1190547 - complete
corrected
added D5720-041

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					